

Print:
User:

Tuesday, 27/01/2009 11:11:09 AM
Julie Dawson

Process Sheet

Split for qty 1 on this order
205.02.19

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOOR WINDOW
Job Number	: 45270 -2	Part Number	: D3295041
Estimate Number	: 10848	Drawing Number	: D3295 REV D
P.O. Number	:	Project Number	: N/A
This Issue	: 27/01/2009 S.O. No. :	Drawing Revision	: D
Prsht Rev.	: NC	Material	:
First Issue	: 1/1 Type : SMALL /MED FAB	Due Date	: 10/02/2009 Qty: 4 Um: Each
Previous Run	: 41796		
Written By	:		
Checked & Approved By	: <u>JUD 09.01.27</u>		
Comment	: Est. C 05.06.20 D3295-1 no longer made in-house KJ/JLM Est Rev:D Added DT8822 07-03-20 JLM Est Rev:E Returned Manufacturing In House 07-06-26 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MLEXS125 9034 01	1/8" 9034 Lexan Sheet
Comment: Qty.: 1.3020 sf(s)/Unit Total : 5.2080 sf(s) 1/8" Thick Lexan 9034 sheet Batch: <u>106173</u> <u>B 9-1-31</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3295 Dwg Rev: <u>B</u> <u>B 9-1-31</u> Prog Rev: <u>B</u> 2-Remove plastic and wrap in saran wrap. 2-Deburr if necessary <u>B 9-1-31</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>B 9-1-31</u>		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>S 09/02/02</u> <u>HIS</u>		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3295-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>45270-2</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief/Eng	Sign & Date			
9/2/2	# 20	During inspection found Qty ③ windows with a Step cut from water jet R.C. Machine malfunction.		Blend out the step. parts acceptable within tolerance.	BB 09/02/17			S 09/02/17
9/2/2	# 20	During inspection found Qty ① window with many scratches.		Scrap and Destroy Qty ① no replace correctors	BB 09/02/17			S 09/02/17
		on it in the field of view R.C. improper storage after water jet. Sand in between parts.		were made Ensure windows are boxed off to remove abrasive prior to stacking.	BB 9-2 09/02/17			S 09/02/17

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR WINDOW

Job Number: 45270

Part Number: D3295041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D3295.
Put window in plastic wrap.

SAD 09-02-17

15

6.0

D27281

Dart Logo label



Comment: Qty.: 0.0000 Each(s)/Unit Total: 0.0000 Each(s)
Dart Logo label small
Pick:

Qty

Part Number

Description

Batch

1

D2728-1

Decal

B391012

SAD

09-02-17

15

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

209-02-19 ①

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: 217

9/2/19

10

SP

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/19

Job Completion



MR
09-02-19

DART AEROSPACE LTD		Work Order: 45270
Description: Window		Part Number: D3295
Inspection Dwg: D3295	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.156	+0.005/-0.001	.156	*			
17.13	+/-0.030	17.13	*			
10.43	+/-0.030	10.43	*			
14.35	+/-0.030	14.35	b			
8.98	+/-0.030	8.983	*			
0.625	+/-0.010	.616	*			
7.109	+/-0.010	7.107	*			
15.845	+/-0.010	15.845	*			
2.308	+/-0.010	2.307	*			
5.420	+/-0.010	5.419	b			
9.402	+/-0.010	9.405	*			
1.312	+/-0.010	1.316	b			
6.260	+/-0.010	6.254	*			
12.520	+/-0.010	12.520	*			
0.313	+/-0.010	.315	b			
3.750	+/-0.010	3.743	*			
8.150	+/-0.010	8.151	*			
9.006	+/-0.010	9.004	*			
0.125	+/-0.010	.121	b			

Measured by: IB	Audited by: S	Prototype Approval:	N/A
Date: 9-1-31	Date: 07/11/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	